

ASA Split

Work Order ID 107207-2

\*107207\*

Page 1

September-23-13 11:23:48 AM

Item ID: D4577-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Access Panel Assembly

Start Date: 9/23/13 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 9/23/13 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals: Process Plan:

Date: 13-09-23

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4577

B

0.00

100

\*100\*

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut D4577-5 as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

Quality Control

5 0 Ac  
13.11.27

5 0 Ac  
13.11.27

6  
12/1/27



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Page 2

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Start Date: 9/23/13 Start Qty: 5.00 \*5\*

Cust Item ID:

Required Date: 9/23/13 Req'd Qty: 5.00 \*5\*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

\*130\*

Small Fab

NC BRAKE

0.00

Small Fab

Memo

C'SINK HOLES AS PER DWG

0.00

140

\*140\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150

\*150\*

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

DAS  
36  
9-89

13/11/28

Smj  
13/11/28

6

6

7/16/13-11-28





**Work Order ID 107207**

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**\*107207\***

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**\*N900040100\***Setup Start **\*NS1\***

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Start Date: 9/23/13 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 9/23/13 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
StampDAS  
36  
9-89

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*2x**13/12/09*

170

0.00

**\*170\***

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

*2x**13/12/09*DAS  
36  
9-89

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

DAS  
27  
8-89*13/12/09**2*





# Work Order ID 107207

September-23-13 11:23:48 AM

\*107207\*

Page 4

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Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Access Panel Assembly

Start Date: 9/23/13 Start Qty: 5.00 \*5\*

Cust Item ID:

Required Date: 9/23/13 Req'd Qty: 5.00 \*5\*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200	Gloss Grey (4.3.5.15) per QSI 005 4.3	0.00							
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\*200\*

Powdercoat

Powder Coating

Memo

\*\*\*\*\*Top side only\*\*\*\*\*

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

Primer: 126558

Paint: 127250

2

0

0

13-12-30

210

\*210\*

QC

Quality Control

QC- Inspect Part Finish

Memo

0.00

0.00

2

14-01-02

220

\*220\*

Packaging

Packaging

Identify as per dwg & Stock Location: ST142

Memo

0.00

0.00

2

DAS  
33  
9-89

14-01-07





**Work Order ID 107207**

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**\*107207\***

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**\*N900040100\***Setup Start **\*NS1\***

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Start Date: 9/23/13 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 9/23/13 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

QC21- Final Inspection - Work Order Release

0.00

**\*230\***

QC

Memo

0.00

Quality Control

11/14-01-09



# Picklist Print

September-23-13 11:23:47 AM

Page 1

Work Order ID: 107207  
 Parent Item: D4577-041  
 Parent Item Name: Fwd Access Panel Assembly

Start Date: 9/23/13  
 Start Qty: 5.00

Required Date: 9/23/13  
 Required Qty: 5.00

Comments: IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC  
 DWG REV:B DD VERF:EC  
 IPP REV:B 12.04.25 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	124.2562	0.767	4.0368421		13.11.27	

Location	Loc Qty	Loc Code
MAT021	124.2561578	
121473	0.9161578	
123279	72.89	
125257	6.1	
M126075	12.35	
M126610	32	

M127272 → 4.1

MS20426AD3-5  
 Rivet

Purchased No

Location	Loc Qty	Loc Code
GA	5591	
4533	5591	
ST333	3120	
4444	3120	

20

170 Each 8.711.0000 10 50

13/12/09

DAS  
 36  
 9-89

NAS1474R3  
 Anchor Nut

Purchased No

Location	Loc Qty	Loc Code
ST297	22	
124883	22	

13/12/09

DAS  
 36  
 9-89

M127673  
 (10x)

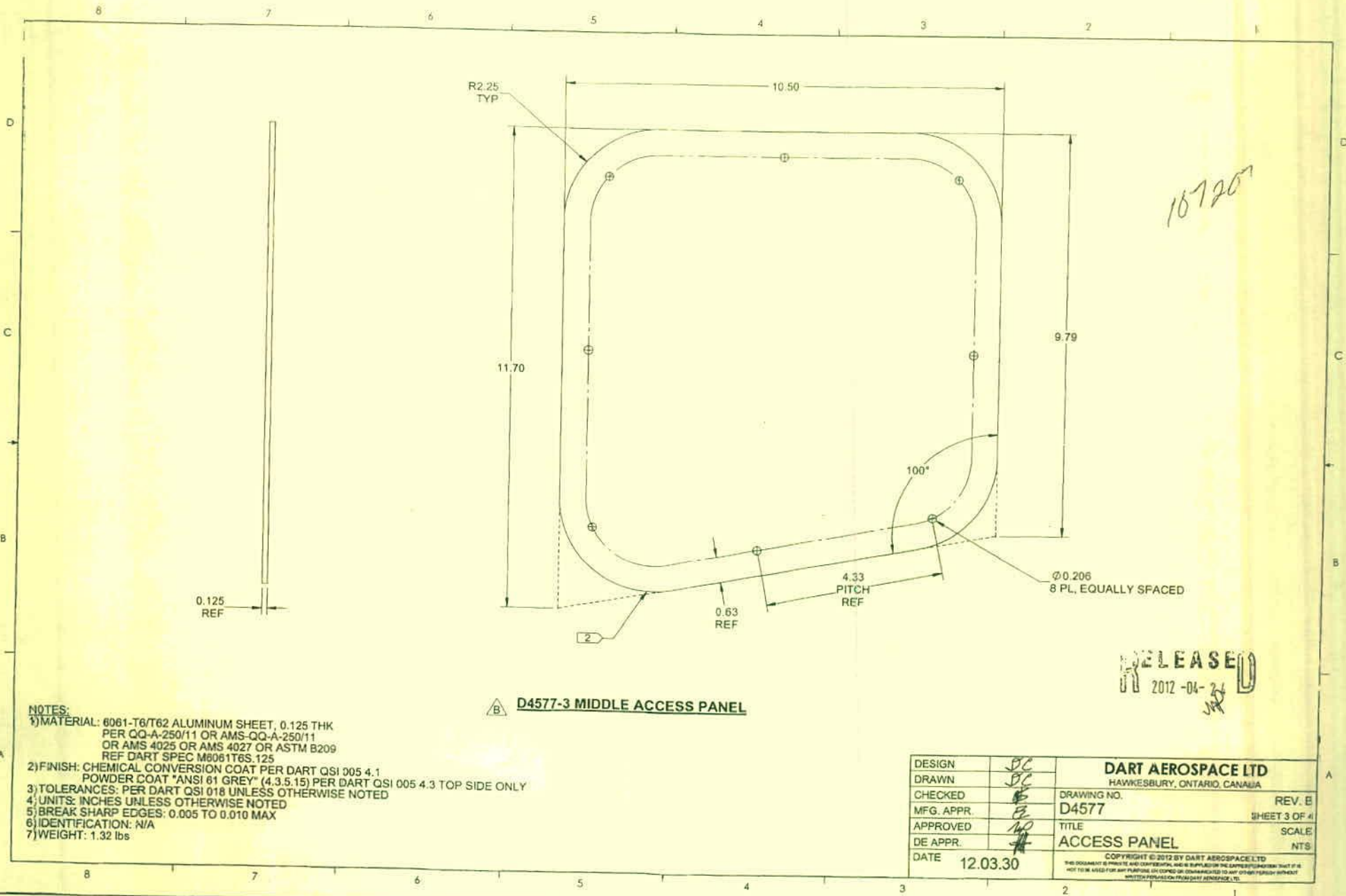


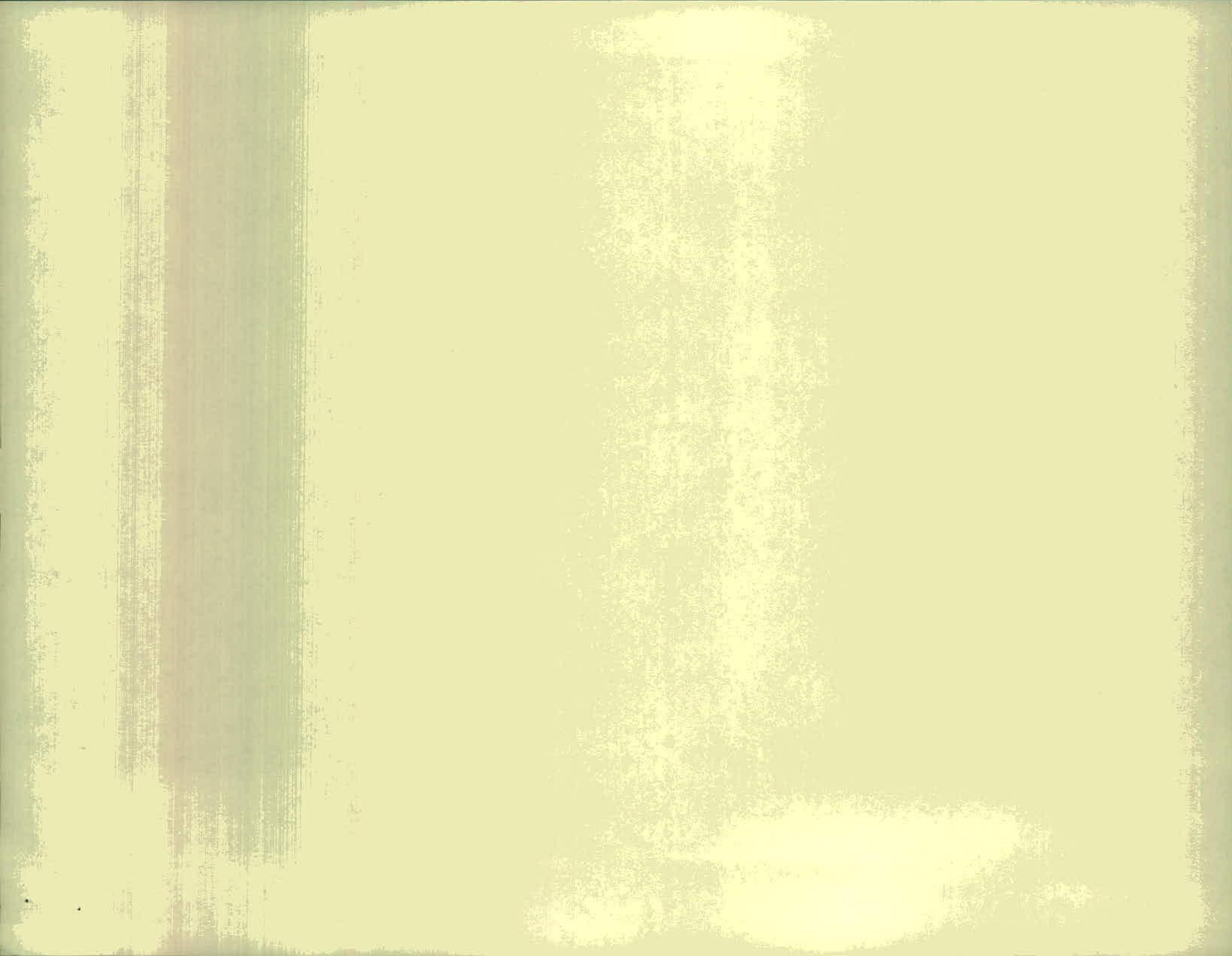








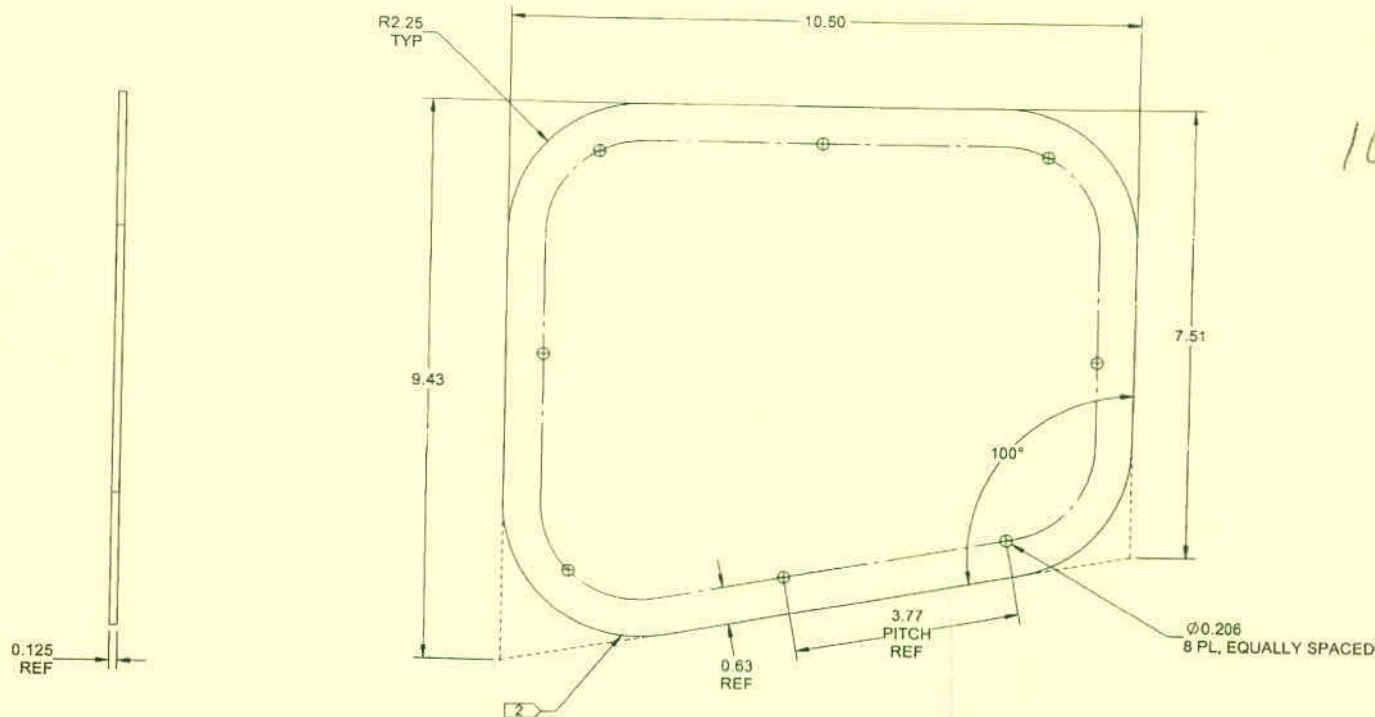












**D4577-1 REAR ACCESS PANEL**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 TOP SIDE ONLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.03 lbs

DESIGN	DC	<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	REV. B
MFG. APPR.	BE	D4577	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	ACCESS PANEL	NTS
DATE	12.03.30	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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2012-04-24

